



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5466-1
Job Sheet 187999



Part No: D5466-1

Job Qty: 10 pcs

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP Rev.B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	2/20/19		0.00	8.62	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/02/17
							HAAS - 4		
120	QC 2	10 pcs	2/20/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		SBL 19/02/22



Container No: S154495



Part: D5466-1

Job No: 187999

Serial No/Batch: S154495

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/17/19

130 QC 8	10 pcs	2/20/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mpt 19/02/25
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	2/20/19	0.00 1.28	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/2/25
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Spray Paint - 2 - B4B	10 pcs	2/20/19	0.00 0.46	Spray Paint - 1 - B4B	• AR 19-2-28
				Spray Paint - 2 - B4B	

				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
160 QC 14	10 pcs	2/20/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 38	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	DAS
				QC 14 - 59	40
				QC 14 - 9	9-89
				QC 14 - 68	
170 Packaging 3-1 - Stock - B4B	10 pcs	2/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5-379
				Packaging 3 - 28 - B4B	MAR 11 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	2/20/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per					
Descriptions: Folio FB551 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB551 and inspect per attached					
Dimension Sheets 3-Machine Step No 3 per Folio FB551 and insp					
120 - (QC2- Inspect parts off machine FAI/FAIB)					
130 - (QC8- Inspect parts - second check)					
140 - (Chemical Conversion Coat per QSI005 4.1)					
150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS					
PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5152590 2-PAINT AS PER DWG AND QSI005 4.2.2.4					
PAINT BATCH: 5146086					
160 - (QC14- Inspect Spray Paint)					

Plex 1/30/19 4:31 PM Dart.Hadley.Shannon

170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 pcs (1 ea)	100-HAAS 4 Axis	8X5136639 2X5147786

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-005	10	32	0

Part Specifications

Specifications could not be found.

Plex 1/30/19 4:31 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5466-1
Job Sheet 187999



Part No: D5466-1

Job Qty: 10 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP Rev.B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	2/20/19	2/20/19	0.00	0.00	Start Up Machining-4		
100	CNC Vertical Machining	10 pcs	2/20/19	2/20/19	0.00	8.62	HAAS1-1		
120	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC2 Machining-4		
130	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC8 Machining-4		
140	HandFinish	10 pcs	2/20/19	2/20/19	0.00	1.28	HandFinish1		
150	SprayPaint	10 pcs	2/20/19	2/20/19	0.00	0.46	Spray Paint		
160	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC14		
170	Packaging	10 pcs	2/20/19	2/20/19	0.00	0.00	Packaging3-2		
180	QC21-SA	10 Ea	2/20/19	2/20/19	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FB551 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB551 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB551 and insp
150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	10	12	0

Part Specifications

Specifications could not be found.

Plex 12/31/18 12:59 PM dart.white.jesse

Handwritten signature/initials

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 187999
Description: Saddle, Fwd, In		Part Number: D5466-1
Inspection Dwg: D5466-1	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.438	0.443	/	0.438	438	438	438	438
B	1.745	1.755	/	1.750	1.75	1.750	1.750	1.750
C	3.495	3.505	/	3.500	3.500	3.500	3.500	3.500
D	1.745	1.755	/	1.750	1.750	1.750	1.750	1.750
E	7.990	8.010	/	8.000	8.000	8.000	8.000	8.000
F	0.490	0.510	/	0.500	500	500	500	499
G	0.257	0.262	/	0.257	0.257	0.257	0.257	257
H	0.375	0.380	/	0.378	0.378	0.378	0.378	378
I	0.490	0.510	/	0.500	0.4975	498	499	498
J	1.174	1.184	/	1.179	1.179	1.179	1.178	1.178
K	0.558	0.578	/	0.5665	0.568	567	569	569
L	1.174	1.184	/	1.179	1.179	1.179	1.178	1.178
M	1.490	1.500	/	1.495	1.495	1.495	1.495	1.495
N	2.495	2.505	/	2.500	2.500	2.500	2.500	2.500
O	3.869	3.879	/	3.872	3.872	3.872	3.872	3.872
P	0.115	0.135	/	0.1315	0.133	133	130	130
Q	0.115	0.135	/	0.126	0.126	0.124	0.127	125
R	0.240	0.260	/	0.256	0.254	0.254	0.255	253
S	0.115	0.135	/	0.129	0.130	131	131	131
T	0.178	0.198	/	0.188	0.188	0.188	0.188	188
U	2.940	2.980	/	2.965	2.965	2.965	2.965	2.960
V	0.230	0.250	/	0.248	0.245	246	244	243
W	0.115	0.135	/	0.132	131	132	130	132
AI	2.000	2.020	/	2.000	2.000	2.000	2.000	2.000
Z	0.352	0.372	/	0.364	362	364	364	364
AA	0.470	0.530	/	0.500	500	500	500	500
AB	0.615	0.635	/	0.623	622	624	622	623
AC	0.053	0.073	/	0.063	0.060	0.065	0.062	0.065
AD	0.240	0.260	/	0.260	0.257	256	256	254
AE	1.375	1.395	/	1.382	1.382	1.382	1.382	1.382
AF	0.115	0.135	/	0.130	0.130	123	130	125
AG	0.240	0.280	/	0.250	0.250	250	250	250
AH	0.240	0.260	/	0.250	0.250	255	250	250

DAS Accept/Reject

Measured by: 57	Date: 19/02/21
Audited by: 9-89	Date: 19/02/25
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 187999
Description: Saddle, Fwd, In		Part Number: 05466-1
Inspection Dwg: D5466-1 Rev: A DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.438	0.443		.438	.438	.438	.438	.438
B	1.745	1.755		1.750	1.750	1.750	1.750	1.750
C	3.495	3.505		3.500	3.500	3.500	3.500	3.500
D	1.745	1.755		1.750	1.750	1.750	1.750	1.750
E	7.990	8.010		8.000	8.000	8.000	8.000	8.000
F	0.490	0.510		.500	.500	.500	.500	.500
G	0.257	0.262		.257	.257	.257	.257	.257
H	0.375	0.380		.378	.378	.378	.378	.378
I	0.490	0.510		.500	.500	.500	.500	.499
J	1.174	1.184		1.179	1.179	1.179	1.179	1.179
K	0.558	0.578		.569	.568	.568	.567	.567
L	1.174	1.184		1.179	1.179	1.179	1.179	1.179
M	1.490	1.500		1.495	1.495	1.495	1.495	1.495
N	2.495	2.505		2.500	2.500	2.500	2.500	2.500
O	3.869	3.879		3.874	3.874	3.874	3.874	3.874
P	0.115	0.135		.130	.132	.131	.131	.130
Q	0.115	0.135		.126	.125	.124	.124	.125
R	0.240	0.260		.254	.252	.251	.253	.252
S	0.115	0.135		.132	.131	.132	.129	.132
T	0.178	0.198		.188	.188	.188	.188	.188
U	2.940	2.980		2.960	2.960	2.960	2.960	2.960
V	0.230	0.250		.242	.244	.243	.243	.244
W	0.115	0.135		.126	.130	.130	.132	.130
AI	2.000	2.020		2.000	2.000	2.000	2.000	2.000
Z	0.352	0.372		.362	.363	.363	.363	.363
AA	0.470	0.530		.500	.500	.500	.500	.500
AB	0.615	0.635		.623	.622	.620	.623	.623
AC	0.053	0.073		.065	.066	.063	.062	.060
AD	0.240	0.260		.252	.255	.255	.254	.255
AE	1.375	1.395		1.386	1.386	1.386	1.386	1.386
AF	0.115	0.135		.135	.130	.128	.126	.130
AG	0.240	0.280		.250	.250	.250	.250	.250
AH	0.240	0.260		.250	.255	.255	.254	.255

DAS Accept/Reject

Measured by: 57	Date: 19/02/22
Audited by: 9-89 mml	Date: 19/02/25
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 187999
Description: Saddle, Fwd, In		Part Number: D5466-1
Inspection Dwg: D5466-1 Rev: A DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.438	0.443						
B	1.745	1.755						
C	3.495	3.505						
D	1.745	1.755						
E	7.990	8.010						
F	0.490	0.510						
G	0.257	0.262						
H	0.375	0.380						
I	0.490	0.510						
J	1.174	1.184						
K	0.558	0.578						
L	1.174	1.184						
M	1.490	1.500						
N	2.495	2.505						
O	3.869	3.879						
P	0.115	0.135						
Q	0.115	0.135						
R	0.240	0.260						
S	0.115	0.135						
T	0.178	0.198						
U	2.940	2.980						
V	0.230	0.250						
W	0.115	0.135						
AI	2.000	2.020						
Z	0.352	0.372						
AA	0.470	0.530						
AB	0.615	0.635						
AC	0.053	0.073						
AD	0.240	0.260						
AE	1.375	1.395						
AF	0.115	0.135						
AG	0.240	0.280						
AH	0.240	0.260						
Accept/Reject								

Measured by:	Date:
---------------------	--------------

Audited by:	Date:
--------------------	--------------

Preliminary Approval:	Date:
------------------------------	--------------

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	